

Work Order ID 85104***85104***

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Friday, June 01, 2012 4:04:28 PM

Item ID: PB67-43001-17

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

12-06-04

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-17

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- grind weld flush in area of PB67-43001-249 only

3- install helicol insert as per dwg

4- assemble parts and weld as per dwg

1 0
*1 0**ll*
12-06-18
FF 12-06-18

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

*1 0**BE 12-06-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:
10:50 OVEN TEMPERATURE: 320°F FINISH TIME: 11:20

176 12-6-20

M/L
IX 12/06/20

M18144

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Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

NR1

QC: Date:

SPC (Y/N): Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

1x of MU 11/00/20

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

1 φ Ae 12.06.25

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 12.06.25

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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
200									
Packaging	Memo	0.00							6/6/25 J
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/6/26 J

MK
12-06-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 85104

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-71 PB67-43001-71		Manufactured	No				Each	1.0000		1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437A	B85189	1							
				41512		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	7.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		7							
				52480		7							
PB67-43001-253 Gusset		Manufactured	No			100	Each	0.0000	1	1		6/12/06/18	
PB67-43001-254 Gusset		Manufactured	No			100	Each	20.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		20							
				52481		20							
PB67-43001-259 Inner Tube		Manufactured	No			100	Each	2.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST209		2							
				44979		2							
MS124780 HELICAL INSERT		Purchased	No			180	Each	86.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		86							
				111064		86							

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Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

180

Each

126.0000

8

Screw

122027 SP

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

26

120120

26

NAS1149D0316J

Purchased

No

180

Each

0.0000

8

Washer

m19600 SP

NAS1149D0363J

Purchased

No

180

Each

2,183.0000

8

Washer

Location

Loc Qty

Loc Code

ST298

2183

117601

61

118077

1

118612

18

119537

33

120142

13

120308

17

120644

86

121243

494

121524

1460

PB67-43001-73

Manufactured

No

180

Each

7.0000

1

20 Degree Cover Plate

SP

Location

Loc Qty

Loc Code

ST437A

7

53305

7

PB67-43001-83

Manufactured

No

180

Each

11.0000

1

PB67-43001-83

SP 126-21.

Location

Loc Qty

Loc Code

ST444

11

53240

11

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

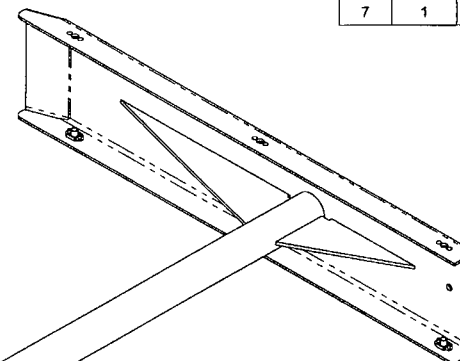
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ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT



85104

RELEASED
2010-09-16

B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-17W	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS	
DATE	10.04.28	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

Dart Aerospace Ltd

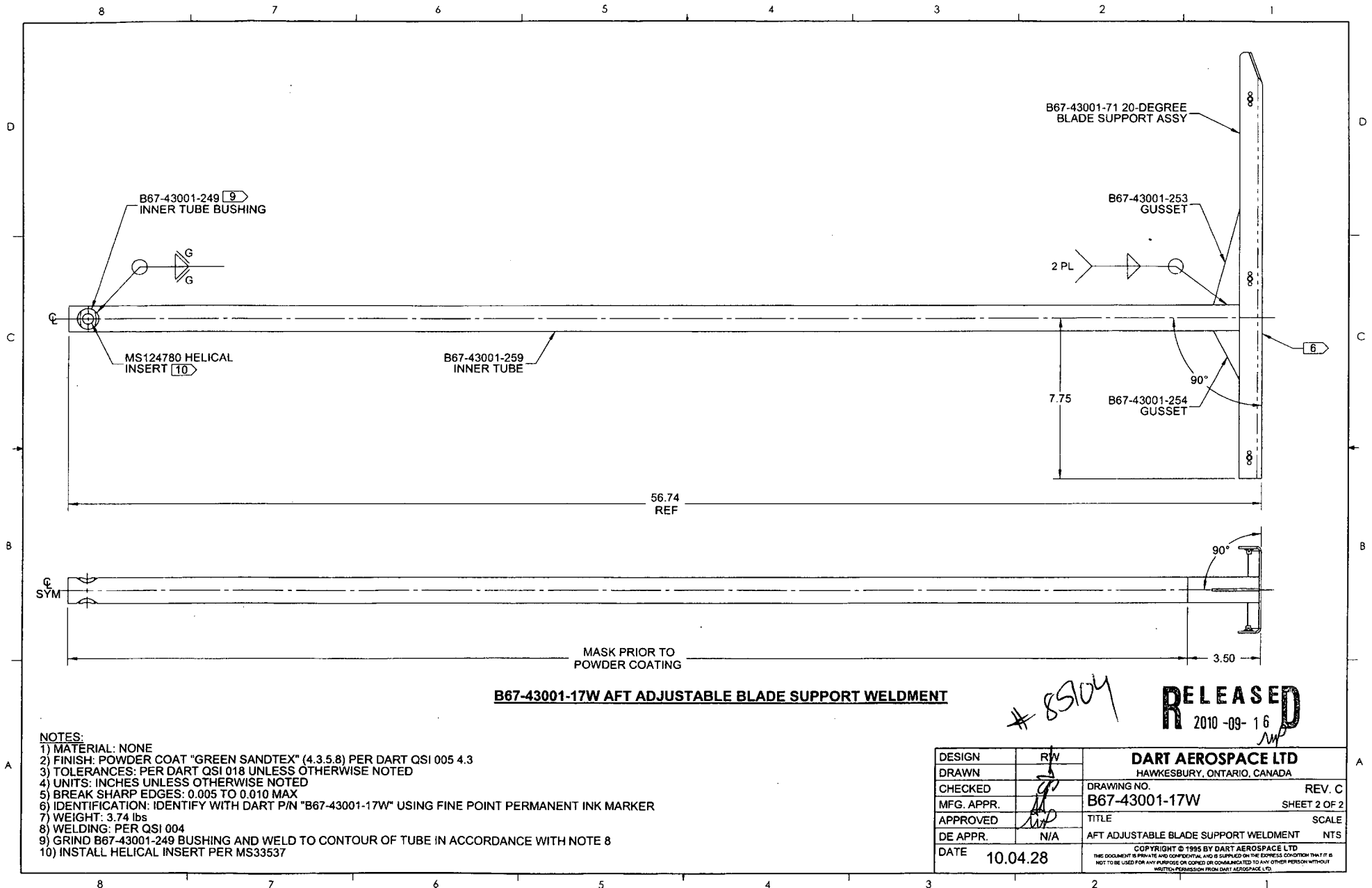
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